

Date: Thursday, 01/05/2008 9:45:51 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING LUG		
Job Number	: 38919		Part Number	: D22303		
Estimate Number	: 10256		Drawing Number	: D22303, REV F		
P.O. Number	:		Project Number	: N/A		
This Issue	: 01/05/2008	S.O. No. :	Drawing Revision	: F		
Prsh Rev.	: NC		Material	:		
First Issue	: / /	Type : MACHINED PARTS	Due Date	: 15/05/2008	Qty:	200 Um: Each
Previous Run	: 38532					
Written By	:					
Checked & Approved By	: <u>JUL 08.5.01</u>					
Comment	: Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:		
1.0	D2423	Lug Extrusion		
		Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s)		
		Lug Extrusion		
		D2423		
		Batch: <u>B33310</u>		
2.0	BAND SAW	BAND SAW		
		<i>Cut at Meter</i>		
		Comment: Band Saw		
		Cut D2423 extrusion to 0.82"		
		Batch: _____		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		<i>Issue P.O. 6274</i>		
		Comment: HAAS CNC VERTICAL MACHINING #1		
		Machine per folio D2230-3		
		Check for crack while loading into the machine.		
		<i>Machine per drawing D2230 Rev.F 008/05/01</i>		
				<i>200</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		<i>Receive + inspect for transit damage</i>		
		<i>Ensure C of C attached</i>		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC5	SECOND CHECK		
		<i>DSPOB</i>		
		Comment: SECOND CHECK inspect level 5		
		<i>So 08/05/20 (+200)</i>		
				<i>coasters</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____
 QA: N/C Closed _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 9:45:51 AM.
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 38919;

Part Number: D22303

Job Number:



Seq #: Machine Or Operation:

Description

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE



Comment: SMALL & MEDIUM FAB RESOURCE #1

Tumble and deburr rough edges after tumbling

08/05/20

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



200

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MF 08-05-20

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

200

9.0 POWDER COATING

POWDER COATING



M107925

200X

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

12:15

START TIME:

320°F

OVEN TEMPERATURE:

12:45

FINISH TIME:

mf

08/05/21

200

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

08/05/21

200

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Reb/26 200

12.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/27/08

Comment: FINAL INSPECTION/W/O RELEASE

MF 08-05-26

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38919
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	Audited by:	Prototype Approval:	N/A
Date:	Date:	Date:	

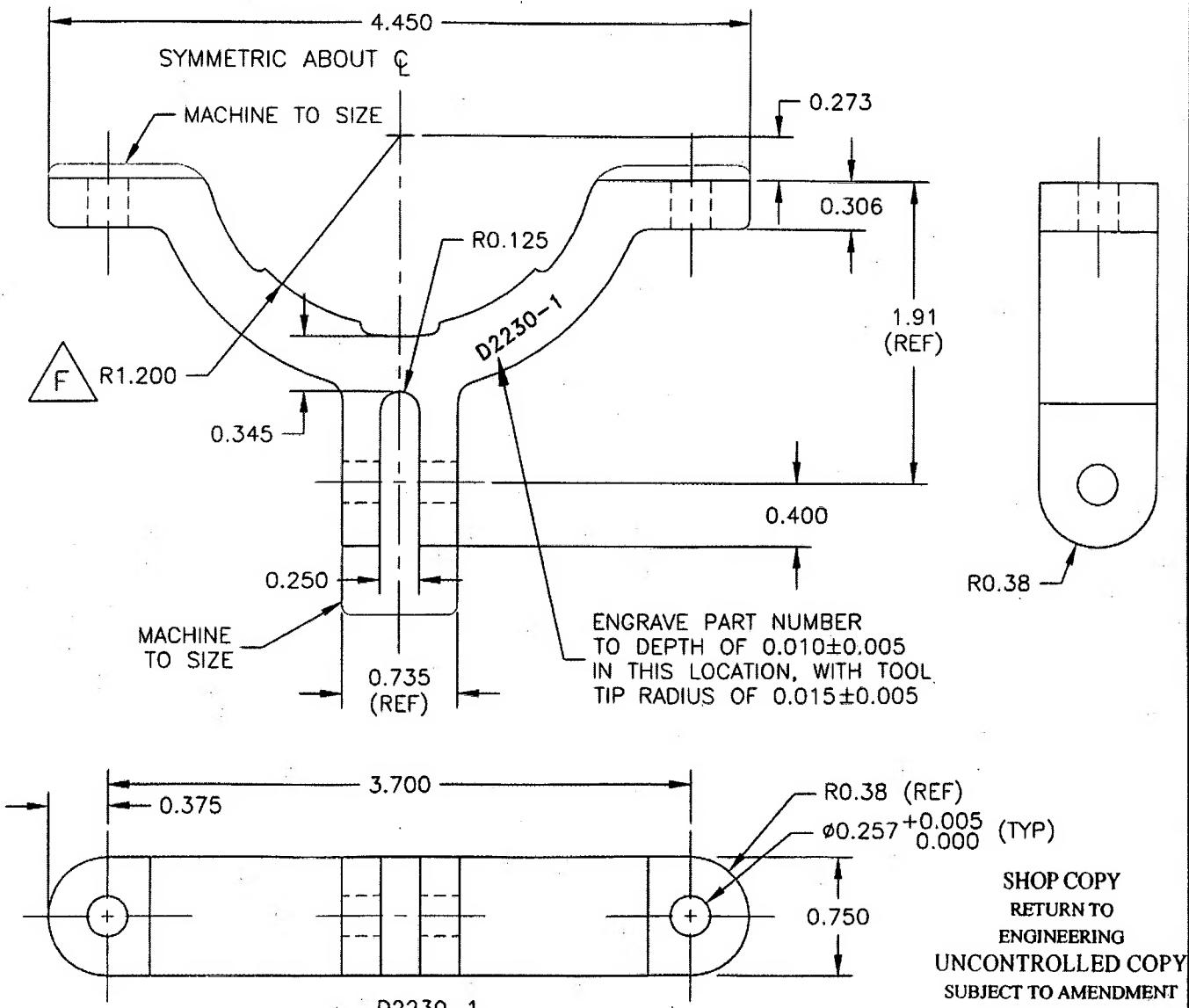
Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	[Signature]

DARTCOPY ISSUED
BY DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2230
DATE 99.12.13	TITLE MOUNTING LUG	REV. F SHEET 1 OF 2 SCALE 1:1
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

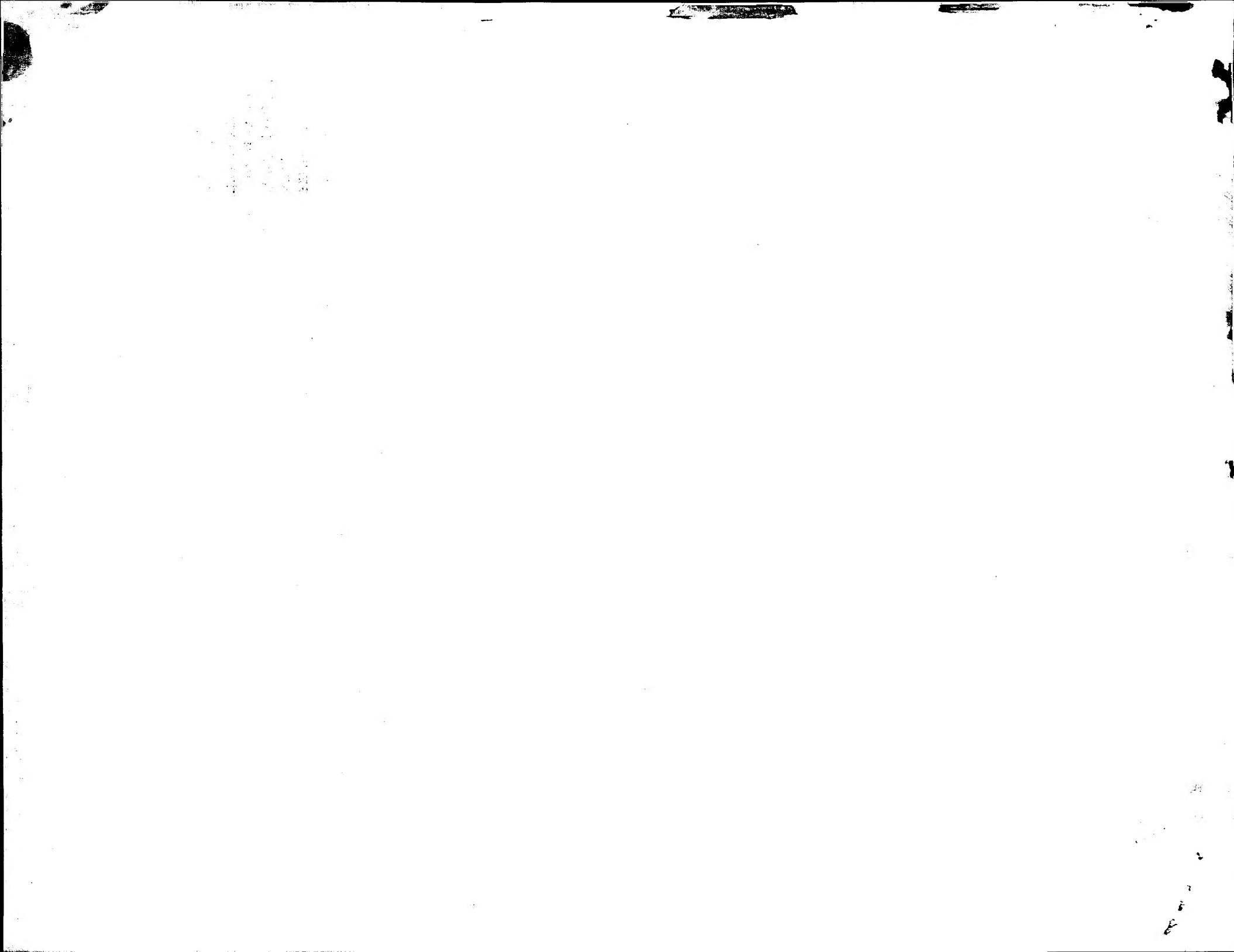
RELEASED

99.12.21 DS



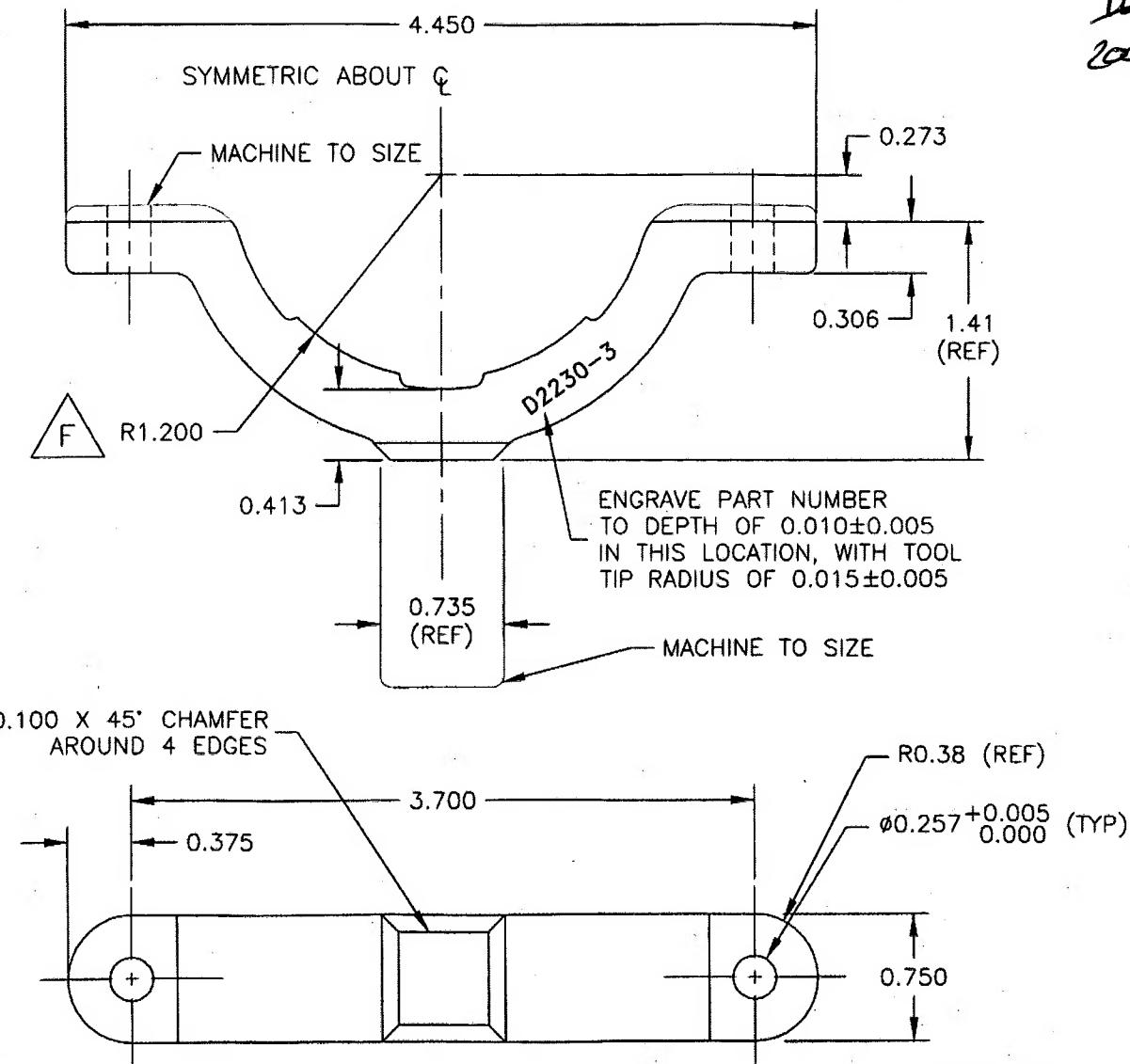
MAKE FROM EXTRUSION D2423
 BREAK ALL EDGES 0.000-0.015
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 38919



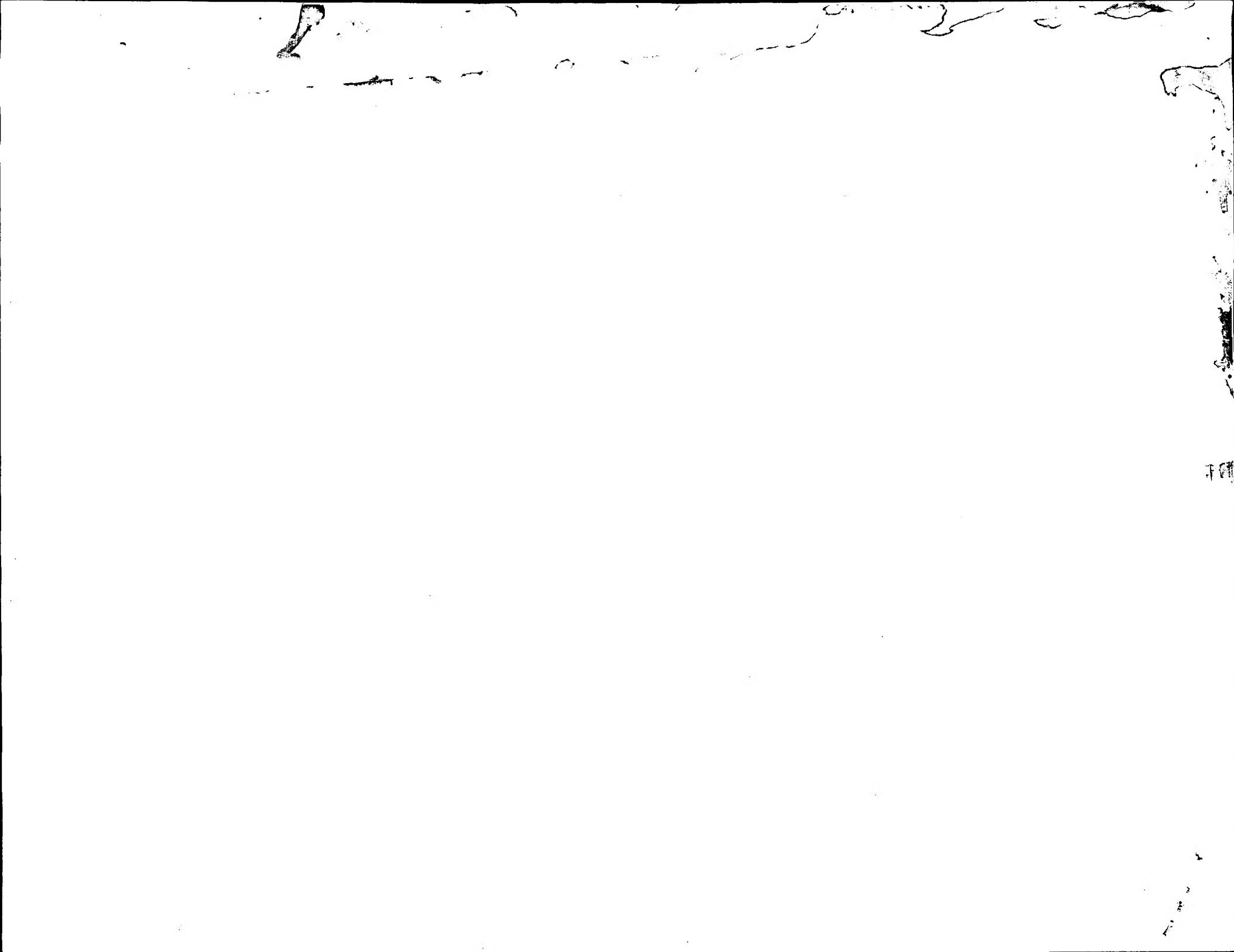
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
DATE		TITLE MOUNTING LUG

REV. F
SHEET 2 OF 2
1:1**RELEASED**
99.12.21 DS100
100
100
200

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28919





CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
200	D2230-3	Lug B38919	6276

MATERIAL: supplied by DART D2-23 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

Shig Walz
METEC Metal Technology Inc.

Shig Walz

Vankleek Hill, May 16, 2008

